

Date: Thursday, 10/18/2007 8:04:30 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR PANEL
Job Number : 35232	
Estimate Number : 11401	
P.O. Number : <u>N/A</u>	Part Number : D32961
This Issue : 10/18/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3296 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 33125	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 10/31/2007 Qty: <u>30</u> Um: Each
Checked & Approved By : <u>[Signature]</u> 07.10.18	
Comment : Est C 05.10.14 Added step 14 KJ/EC Est Rev:D Now on Waterjet 06-11-02 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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20.778



Comment: Qty.: 0.6926 sf(s)/Unit Total : 13.8516 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.063" thick
(M2024T3S.063)
Identify for D3296-1
Batch: 105615 1807-10-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3296
Dwg Rev: A
Prog Rev: A

1807-10-22



2-Deburr if necessary 1807-10-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1807-10-22



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 07/10/23



counter

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

N/A 5 07/10/23
Done @ step 2.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOOR PANEL

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HS

04-10-23

(30)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(30)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/10/24

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 110

(30x)

AS 07/10/24

LE

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/24

Job Completion



U 07-10-24



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

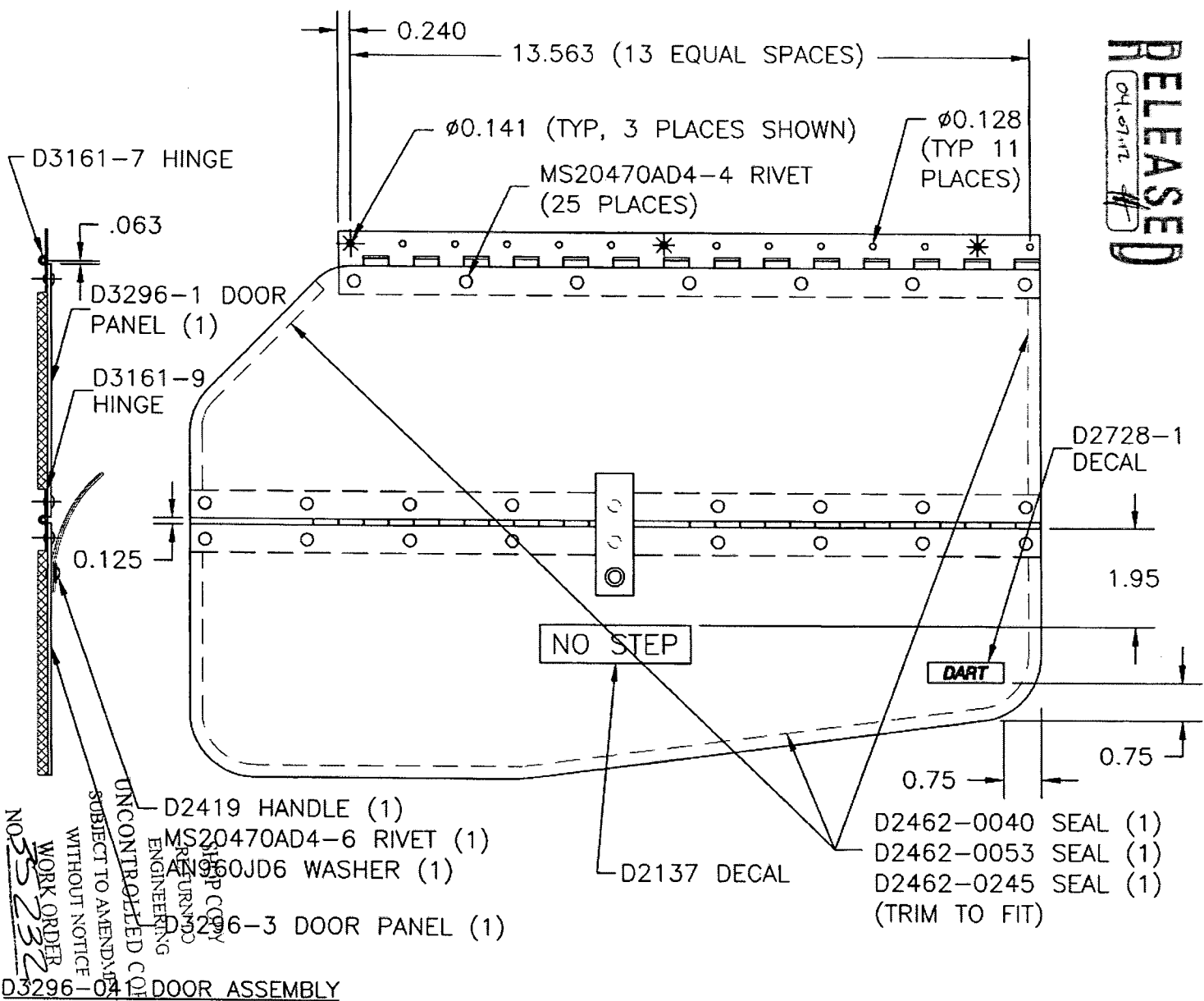
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
UP		UP		HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. A
				D3296	1 OF 2
DATE				TITLE	SCALE
04.06.28				DOOR ASSEMBLY	1:3
A		04.06.28		NEW ISSUE	

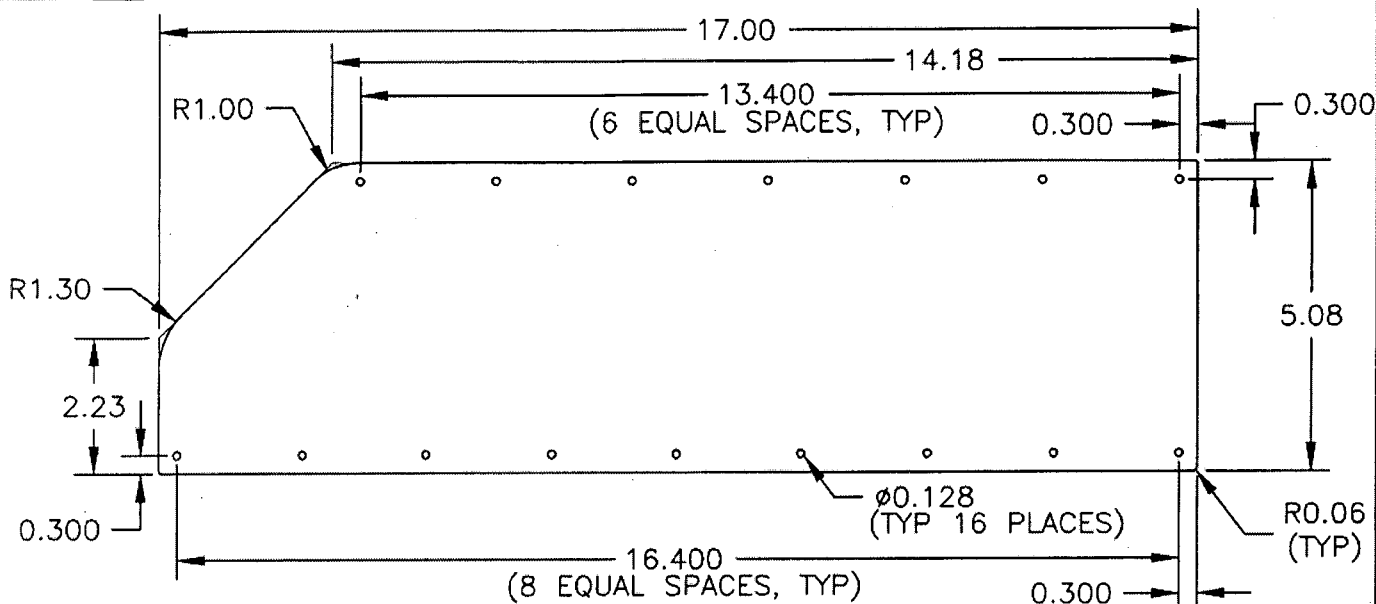
RELEASED
04.07.12



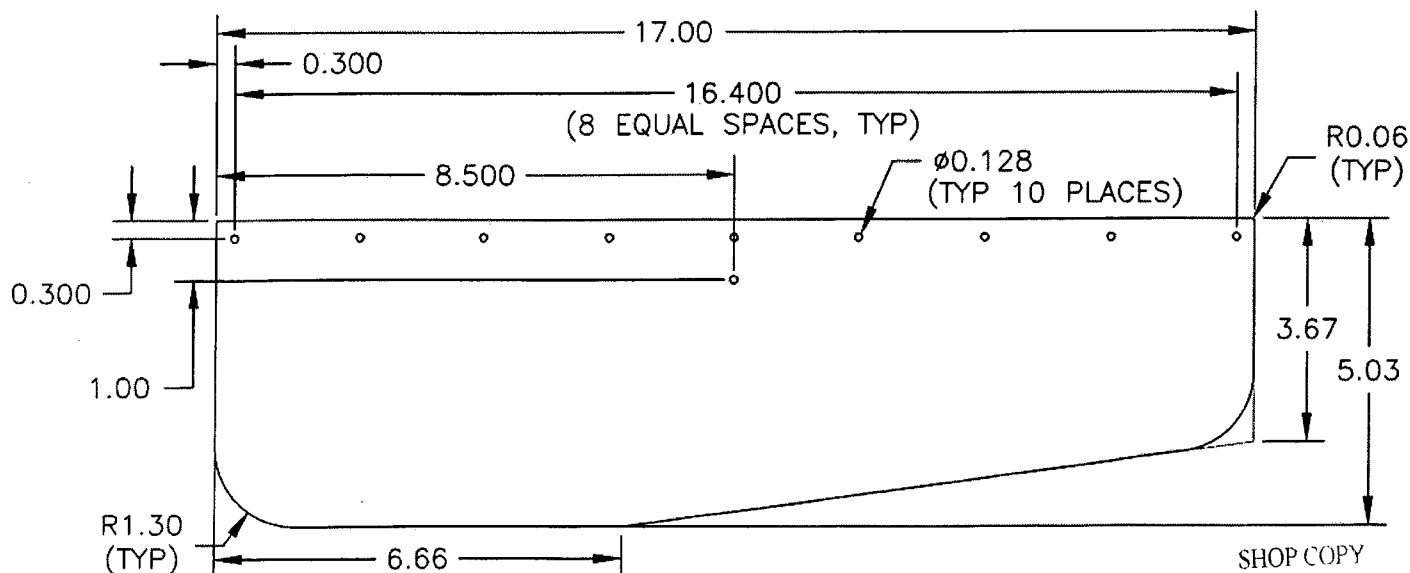
- D3296-041 DOOR ASSEMBLY
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
RELEASED
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35232

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